

Slp 29/4

Date: Monday, 11/19/2007 4:06:11 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT STRUT ASSEMBLY
Job Number	: 35872		
Estimate Number	: 11242		
P.O. Number	: N/A	Part Number	: D3437043
This Issue	: 11/19/2007 S.O. No. : N/A	Drawing Number	: D3437 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 27063	Material	: N/A
Written By	:	Due Date	: 11/29/2007 Qty: 4 Um: Each
Checked & Approved By	: <u>AS 07/11/20</u>		
Comment	: Est. A 05.05.20 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34371 Foot



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Foot

Pick:

Qty	Part Number	Description	Batch
1	D3437-1	Foot	B34313

AS 07/11/26 (x4)

2.0 D34373 Clip



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clip

Pick:

Qty	Part Number	Description	Batch
1	D3437-3	Clip	B27065

AS 07/11/26 (x4)

3.0 D34379 Eye Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Eye Bolt

Pick:

Qty	Part Number	Description	Batch
1	D3437-9	Eye Bolt	B35888

AS 07/11/26 (x4)

4.0 AN960C516 WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
2	AN960C-516	Washer	M17697

AS 07/11/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/11/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:06:11 PM
User: Kim Johnston

29/11
Ship Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT STRUT ASSEMBLY

Job Number: 35872

Part Number: D3437043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MS210435

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Self Locking Nut

Pick:

Qty Part Number

Description

Batch

1 MS21043-5

Self Locking Nut

M105430

KS 07/11/26 (x4)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3437 Dwg Rev:

B

ml07/11/26

PTO

7.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

KS 07/11/26 (x4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W

KS 07/11/27

(x4)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

KS 07/11/27 (x4)

Job Completion





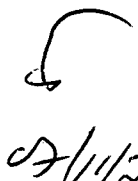


W 07.11.27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/11/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/26	6	Have to Re-pick 3 Eye-Bolt 1-2 - was stripped 3 - was crocked	 Q5722	Scrap them Replace by new one <u>AB 35888</u>	 07/11/26	 07/11/26	 Q5722	 07/11/26

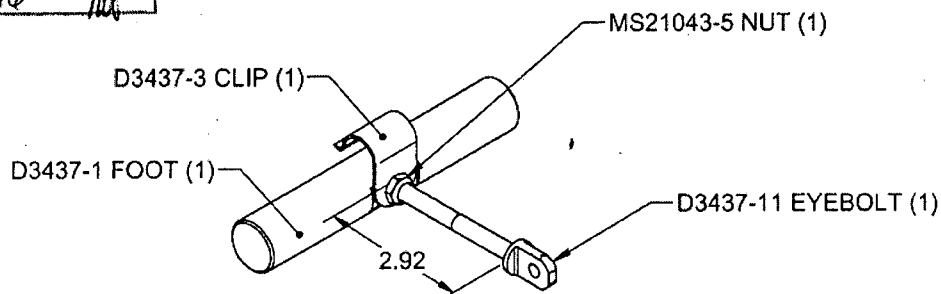
NOTE: Date & initial all entries



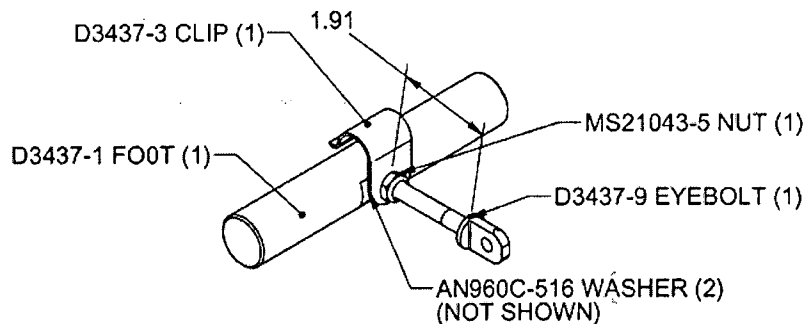
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3437	REV. B SHEET 1 OF 4
DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2
A	05.04.29	NEW ISSUE	
B	05.08.11	UPDATE D3437-5/-9/-11 DIMENSIONS	

RELEASED

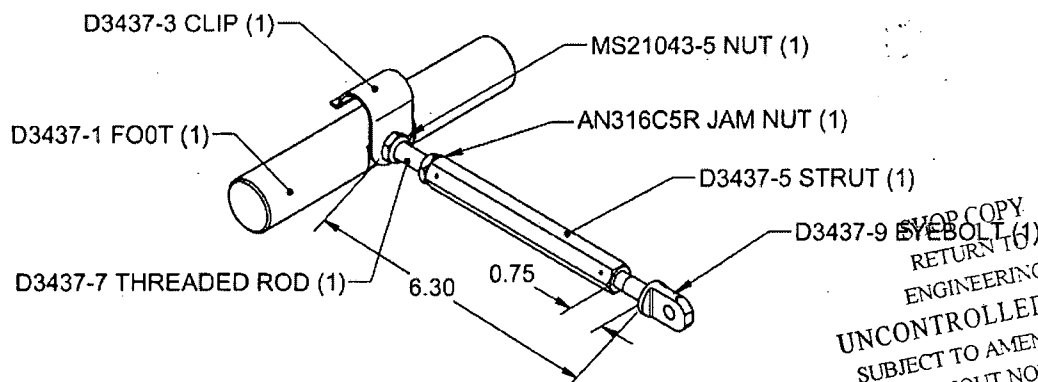
05.08.16 *[Signature]*



D3437-041 AFT STRUT ASSEMBLY



D3437-043 AFT STRUT ASSEMBLY



D3437-045 AFT STRUT ASSEMBLY

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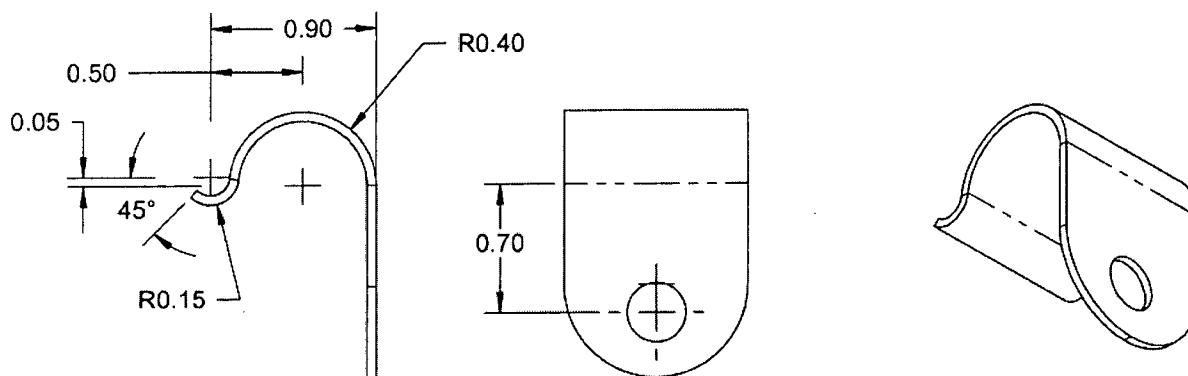
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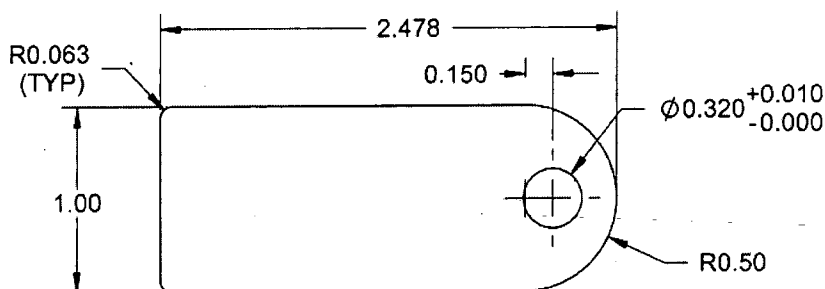
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DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2

RELEASED

05.08.11 *[Signature]*



D3437-3 CLIP
SCALE 1:1



D3437-3
FLAT PATTERN

D3437-3 CLIP:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK (REF DART SPEC M304S1804)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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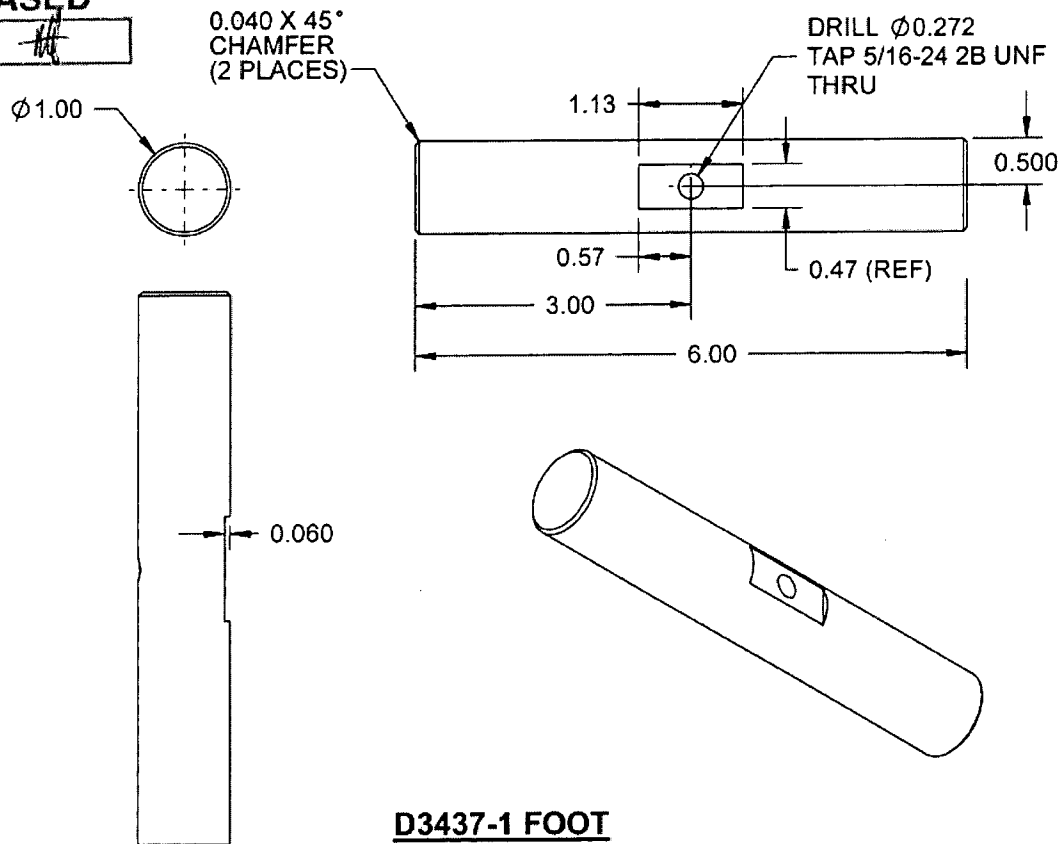
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CHECKED 	APPROVED 	DRAWING NO. D3437	REV. B SHEET 3 OF 4
DATE 05.08.11	TITLE AFT STRUT ASSEMBLY		SCALE 1:2

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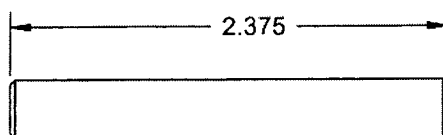
05.08.11



D3437-1 FOOT

D3437-1 FOOT:

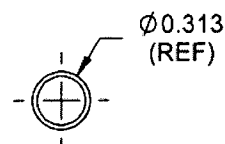
- 1) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) ALUMINUM ROUND BAR (REF. DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



D3437-7 THREADED ROD

D3437-7 THREADED ROD:

- 1) POSSIBLE SUPPLIER: HASKINS-SPAENAU P/N 870-832 18-8 5/16-24 SS THREADED ROD
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



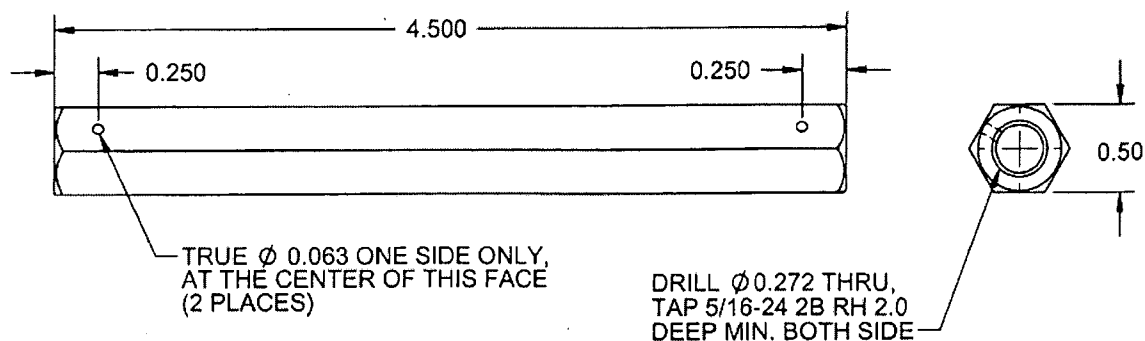
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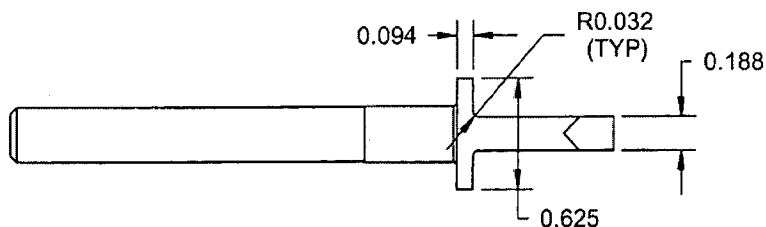


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DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2



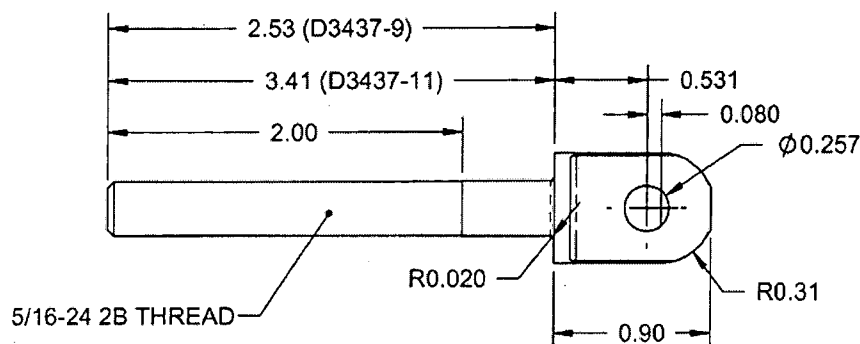
D3437-5 STRUT:

- 1) MATERIAL: AISI 303 STAINLESS HEX BAR (DART REF. SPEC M303H0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



RELEASED

05-08-16 *[Signature]*



D3437-9/-11 EYEBOLT:

- 1) MATERIAL: AISI 303 STAINLESS ROUND BAR (DART REF. SPEC M303R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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